

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006762**Date Inspected:** 14-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/14/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works, Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E3 - Magnetic Particle (Dry Powder) inspection per SF-MT-01 of WQCP by Technician R.Kumagai #132 of contoured welds. Joints under scrutiny by inspector were E3Y-9U (plate 3-9 to cast) and E3S-2U (Cast stem to plate stem). All inspection parameters appear met at this time.

W2W1 - K.Nakasato 91-2247, welding joint W1Y-13U using FCAW per procedure SJ-3011-7 using 1.6mm, weld wire TM95; welder T.Watanabe 08-5153 was welding W1Y-14U per SJ-3011-6. All weld parameters were verified by QC CWI Chung F. Kuan.

W2W3 - All plates for built up section are now fit up and tacked in place, welder R.Kito was in process of attaching temporary attachments, strong backs spanning outside ribs, using SMAW process with E7016 electrode in preparation for root passes to begin tomorrow.

TOWER SADDLES

T1-2 - In preparation for attachment to base plate, all plate rib bevels have been ground smooth for MT by Technician R.Kumagai #132 prior to the beginning of fit up process.

T1-3 - Saddle is in process of being inverted to continue welding.

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EAST DEVIATION SADDLES

E2E1 - Three (3) men in process of shaping by way of grinding, appears 90% complete.

E2W1 - All accessible repair excavations have been MT and PT'd, currently awaiting grinding to remove indications inside the excavations.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
